

Work Order ID 93842

93842

Page 1

Monday, November 26, 2012 11:13:38 AM

Item ID: 646.3312 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Center Plate

Start Date: 11/22/2012 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 11/22/2012 Req'd Qty: 20.00 ***20*** Customer:

Reference: *[Signature]* 12-11-23

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
646.3300	N/C								

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blank at 16.300"

*** ONE BLANK MAKES TWO PARTS***

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FB153

DWG REV: *N/C*

FOLIO REV: *AA*

2- deburr and break all sharp edges

FE 12/11/26

and 12/11/30

20 0

20 0

DAS
14
2-83

93842

Monday, November 26, 2012 11:13:38 AM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

20

20

Customer:

Run Start *NR1*

Date:

Stop *NR2*

Date:

Insp. Stamp

0.00

140

Memo

Issue P/O: 18383
Black Anodize as per Dwg 646.3300

0.00

0.00

150

Memo

0.00

0.00

155

Memo

0.00

₹ 20

cont

Work Order ID 93842

93842

Page 4

Monday, November 26, 2012 11:13:38 AM

Item ID: 646.3312 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Center Plate
 Start Date: 11/22/2012 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 11/22/2012 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* SprayPaint Spray Painting	Spray Painting per QSI005 4.2 Memo PRIME AS PER DWG, SEE NOTE #2 PRIMER BATCH: <u>124204</u>	0.00 0.00				<u>20</u>	<u>0</u>	<u>0</u>	<u>Al</u> 13-3-28
170 *170* QC Quality Control	QC14- Inspect Spray Paint Memo	0.00 0.00				<u>20</u>			<u>DAS</u> <u>05</u> <u>13-04-08</u>
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: <u>Med</u> <u>Fab</u> Memo <u>"Russ"</u> ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***	0.00 0.00				<u>20</u>			<u>13-04-08</u>

Work Order ID 93842***93842***

Page 5

Monday, November 26, 2012 11:13:39 AM

Item ID: 646.3312 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Center Plate
Start Date: 11/22/2012 Start Qty: 20.00 ***20*** Cust Item ID:
Required Date: 11/22/2012 Req'd Qty: 20.00 ***20*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

13/4/8

13-04-8

Picklist Print

Monday, November 26, 2012 11:04:39 AM

Page 1

Work Order ID: 93842

Parent Item: 646.3312

Start Date: 11/22/2012

Required Date: 11/22/2012

Parent Item Name: Center Plate

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A NEW ISSUE 12/11/16 JFS VERIFY BY: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T6B5.000X0.375 7075-T6 BAR 5.000" X 0.375"		Purchased	No			100	f	74.2320	0.68	14.31579			

Location

Loc Qty

Loc Code

MAT008

74.232

123218

44.362

123418

29.87

14.316

FK 12/11/26

DART AEROSPACE LTD	Work Order: 93842
Description: CENTER PLATE	Part Number: 646.3312
Inspection Dwg: 46.3300 Rev: N/C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.375	$\pm .005$.372	—		Vern	ML-06
.471	$\pm .005$.471	—		"	
.680	$\pm .002$.690	—		H-G	31006
2.471	$\pm .002$	2.471	—		"	
2.690	$\pm .002$	2.690	—		"	
4.159	$\pm .002$	4.159	—		"	
4.752	$\pm .002$	4.752	—		"	
4.836	$\pm .005$	4.840	—		"	
4.893	$\pm .005$	4.892	—		"	
5.122	$\pm .005$	5.122	—		"	
5.216	$\pm .005$	5.214	—		"	
5.836	$\pm .005$	5.836	—		"	
6.815	$\pm .002$	6.815	—		"	
8.221	$\pm .002$	8.221	—		"	
8.815	$\pm .002$	8.815	—		"	
8.929	$\pm .005$	8.929	—		"	
9.374	$\pm .005$	9.374	—		"	
10.096	$\pm .002$	10.096	—		"	
10.538	$\pm .005$	10.538	—		"	
10.177	$\pm .005$	10.177	—		Vern	ML-06
10.209	$\pm .005$	10.209	—		"	
.313	$\pm .002$.315	—		"	
1.000	$\pm .002$	1.002	—		"	

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Preliminary Approval:
Date: 12/14/29	Date: 12-12-03	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

[Signature] 10.04.15

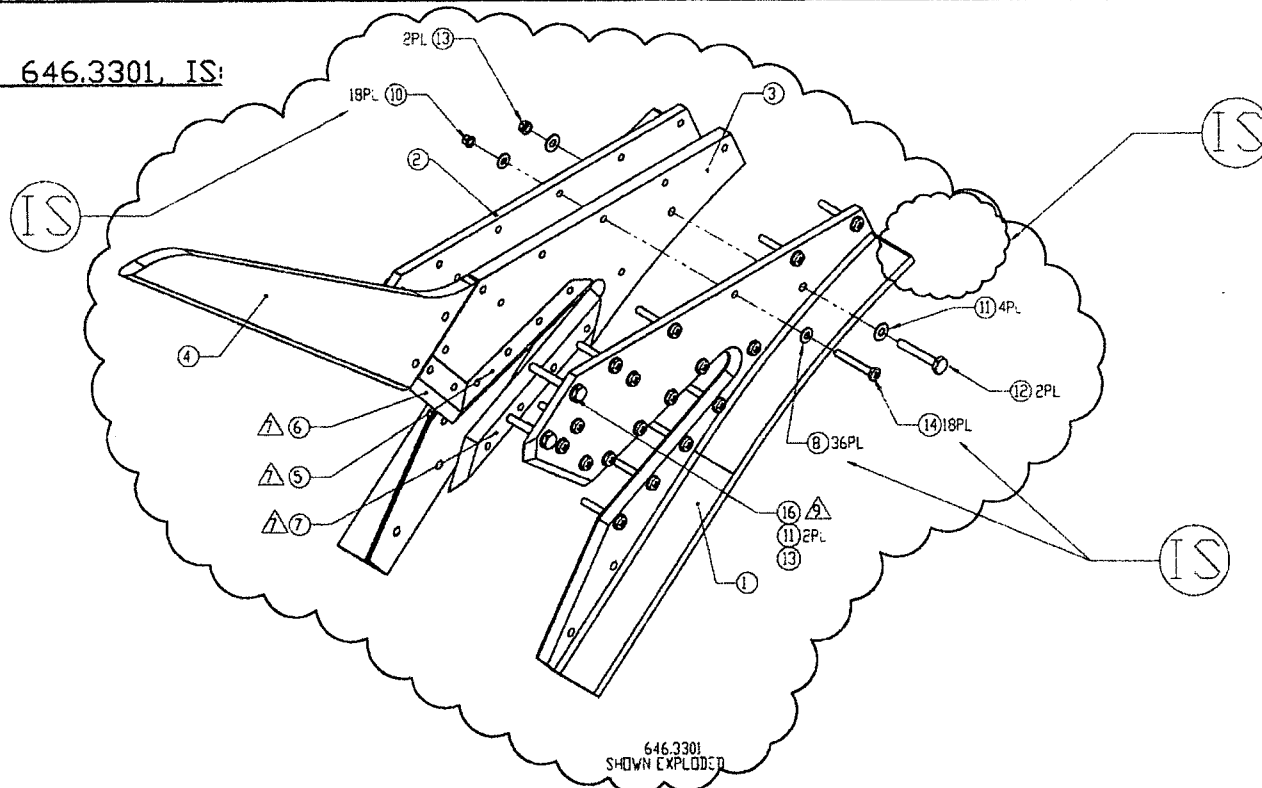
FIRST ARTICLE INSPECTION CHECKLIST

Measured by: <i>af</i>	Audited by: <i>af</i>	Preliminary Approval:
Date: 12/1/29	Date: 12-12-03	Date:

H:\FORMS\Quality Assurance\approved QA\FAI revE

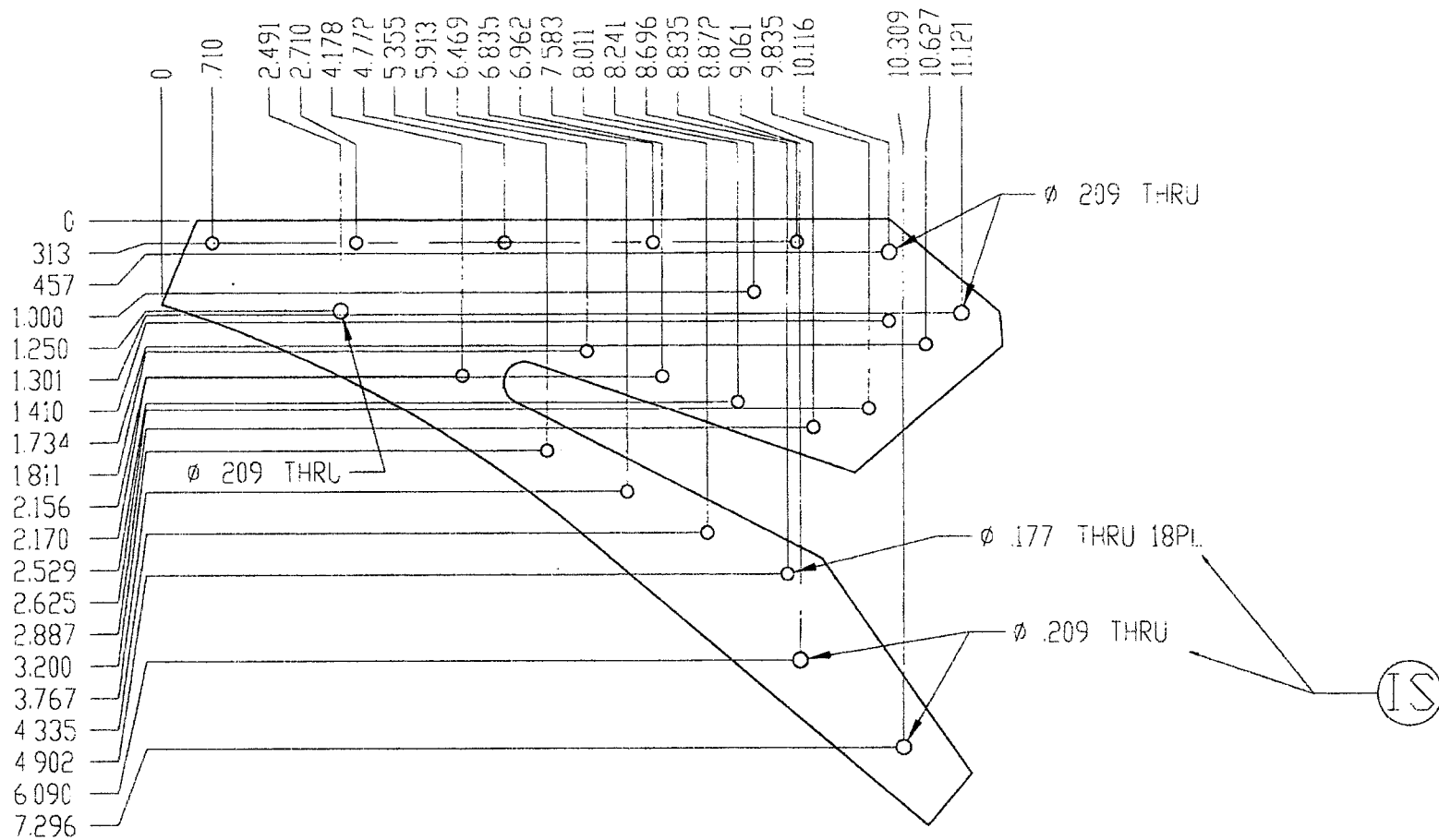
APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 02196				SHEET 1 OF 2	
	DWG NO. 646.3300	REV: N/C	PREPARED BY S. HUFF	DATE: 01/05/09	EFFECT ON DWG <input type="checkbox"/> INC. <input checked="" type="checkbox"/> UNINC.	
	DWG TITLE: UPPER CUTTER ASSY					
APPROVED BY: ENGR <i>[Signature]</i>		MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: NEXT ORDER		
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE		REASON: REMOVED RIVETS IN FAVOR OF ADDITIONAL SCREWS				


SHEET 1, VIEW 646.3301, IS:



14	R	601.2765	18	SCREW	MS27039-0819
10	R	601.1541	18	LOCKNUT	MS21042L08
9	D	601.2766	3	RIVET	MS20470AD5-18
8	R	601.2764	36	WASHER	NAS1149FN832P
			3301		
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION
DOCUMENTS EFFECTED:				<input type="checkbox"/> MDL <input checked="" type="checkbox"/> INSTALL INSTRUC <input checked="" type="checkbox"/> ICA <input type="checkbox"/> FMS <input checked="" type="checkbox"/> BOM	CHANGE CATEGORY <input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR
				DER REVIEW REQUIRED <input type="checkbox"/> YES <input checked="" type="checkbox"/> NO	

SHEET 3, SECTION VIEW A-A, IS:

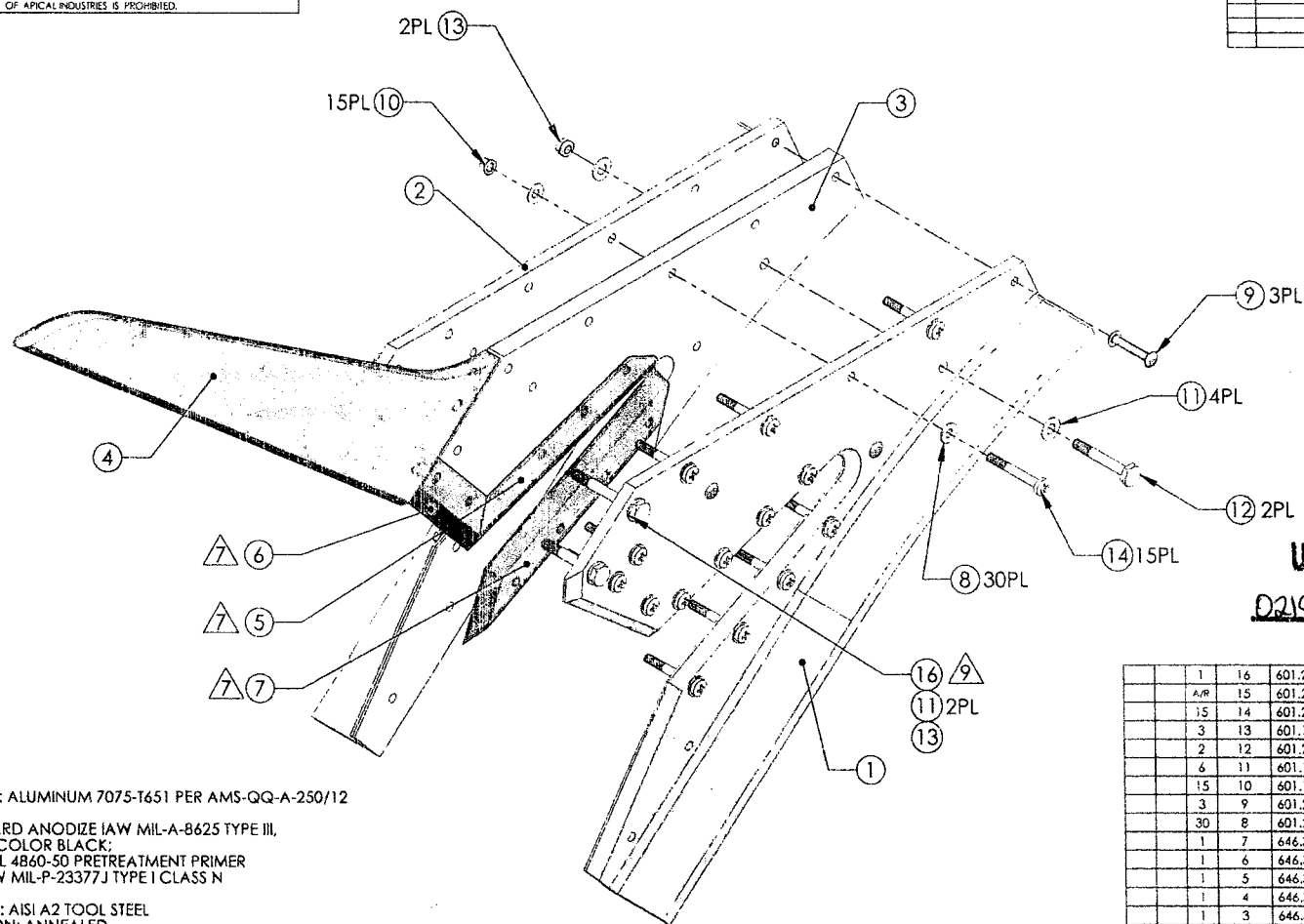


SECTION A-A 

F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



UNINCORPORATED ECN(s)

02196

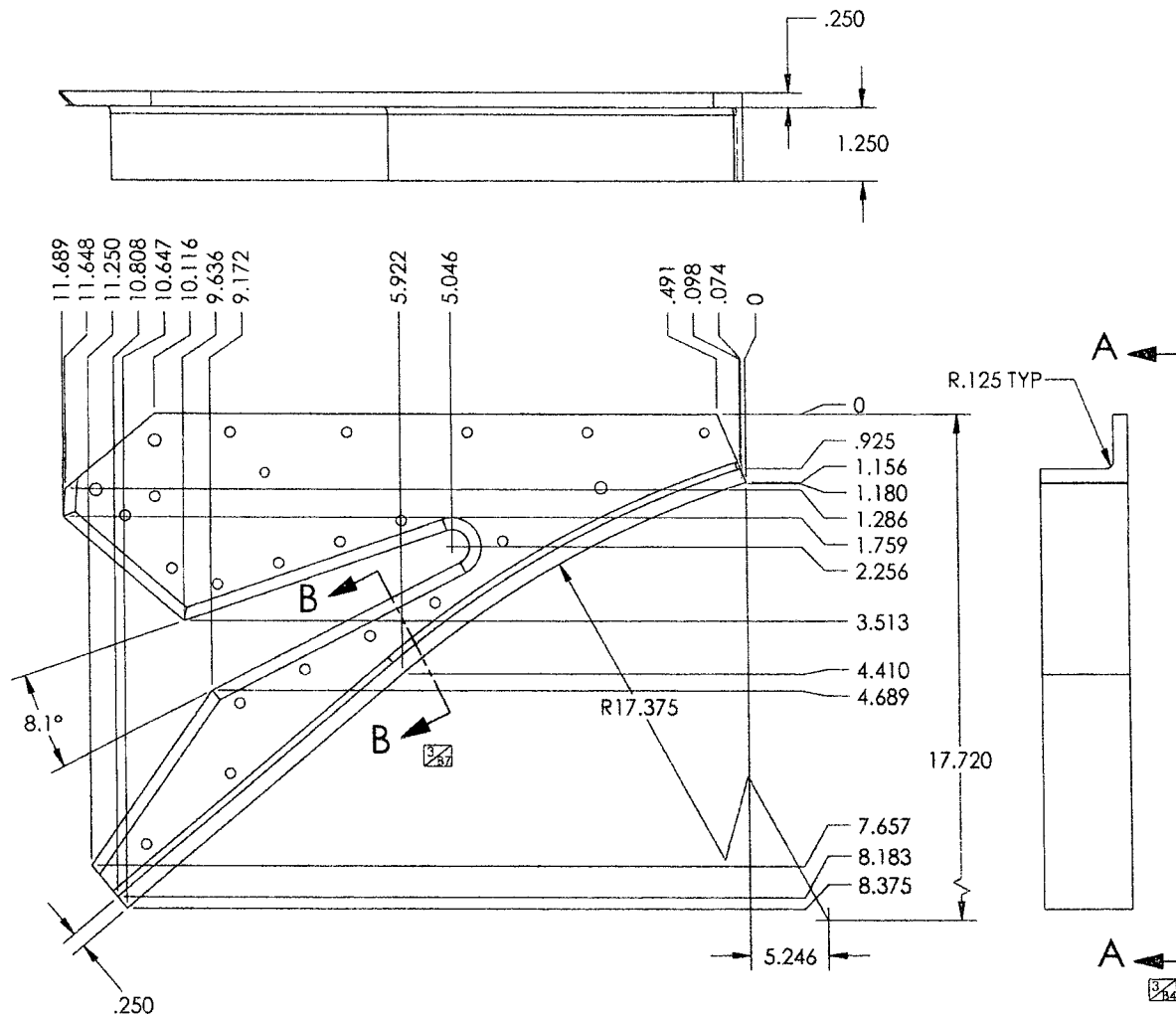
NOTES:

- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; CARDINAL 4860-50 PRETREATMENT PRIMER PRIME IAW MIL-P-23377J TYPE I CLASS N
- 3 MATERIAL: AISI A2 TOOL STEEL; CONDITION: ANNEALED; POST PROCESS: HEAT TREAT TO 58-62 Rc ROCKWELL HARDNESS
- 4 FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N
- 5 DEBURR AND BREAK ALL SHARP EDGES EXCEPT WHERE OTHERWISE NOTED
- 6 IDENTIFY IAW MPP-120
- 7 APPLY F/N 15 AS REQUIRED TO ALL FAYING SURFACES OF F/N 5, 6 & 7 UPON ASSEMBLY
- 8 CUTTING EDGE INTENDED TO BE SHARP, DO NOT BREAK SHARP EDGE
- 9 INSTALL FASTENER FINGER-TIGHT

646.3301
SHOWN EXPLODED

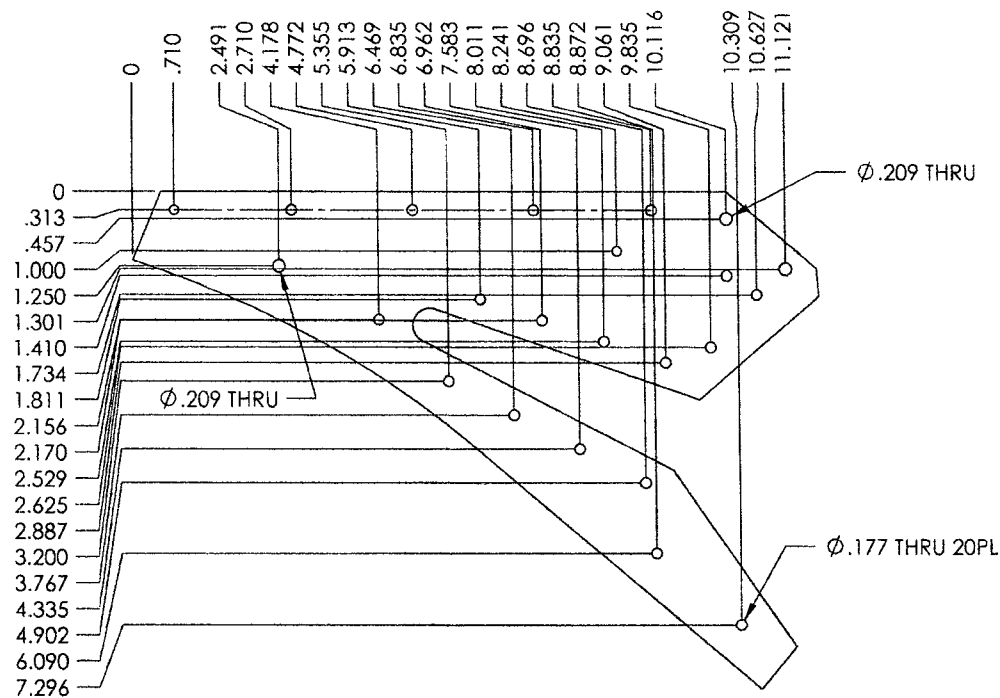
QTY	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
1	16	601.2834	BOLT	A19-14A	
15	15	601.2045	RTV, LOCTITE 598		
15	14	601.2765	SCREW	MS27039-08-19	
3	13	601.1624	LOCKNUT	MS21042L3	
2	12	601.2763	BOLT	A19-12A	
6	11	601.1607	WASHER	MS21042L3	
15	10	601.1541	LOCKNUT	MS21042L3	
3	9	601.2766	RIVET	MS20170A-D5-18	
30	8	601.2764	WASHER	MS21042L3	
1	7	646.3316	BLADE		
1	6	646.3315	BLADE		
1	5	646.3314	BLADE		
1	4	646.3313	UPPER GUIDE		
1	3	646.3312	CENTER PLATE		
1	2	646.3311	RH HALF		
1	1	646.3310	LH HALF		
1		646.3301	UPPER CUTTER ASSY		
PARTS LIST					
ORIGINAL DATE: 08-26-08					
DRAWN BY: P. BRANVO					
CHECKED BY: P. BRANVO					
DRAWING APPROVAL: P. BRANVO					
CONTRACT NO:					
UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES					
TOLERANCES ARE: 1 PLACE DECIMALS ± .01					
2 PLACE DECIMALS ± .005					
3 PLACE DECIMALS ± .001					
ANGLE: 1°					
NEXT ASSY (S): 646.4000					
APICAL INDUSTRIES					
2608 TEMPLE HEIGHTS DR.					
OCEANSIDE, CA. 92056-3512 (760)724-5300					
UPPER CUTTER ASSY					
SCALE: NONE					
SHEET 1 OF 8					

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ORIGINAL DATE MM-DD-YY 09-24-08		APICAL INDUSTRIES	
DRAWN BY T. HUFF	CHECKED P. BRAYO	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL P. BRAYO		UPPER CUTTER ASSY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.001 ANGLES ±.5°		SHEET B	REV N/C
CAGE CODE 07M26		DWG NO. 646.3300	SCALE: NONE
		SHEET 2 OF 8	

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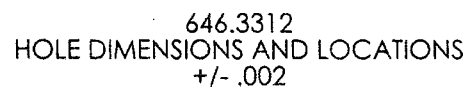


SECTION A-A

SECTION B-B

ORIGINAL DATE (MM-DD-YY) 08-26-08		APICAL INDUSTRIES	
DRAWN BY S. HUFF	CHECKED P. BRAVO	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWING APPROVAL		UPPER CUTTER ASSY	
CONTRACT NO.		SCALE NONE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.1°		SMT B	REV N/C
		CAGE CODE 07M16	QTY NO 646.3300
		SHEET 3 OF 8	

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

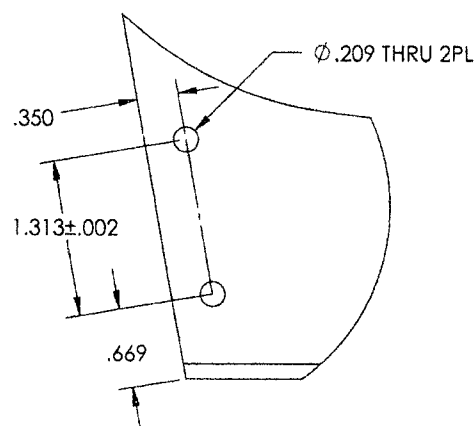
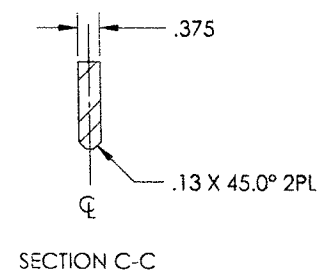
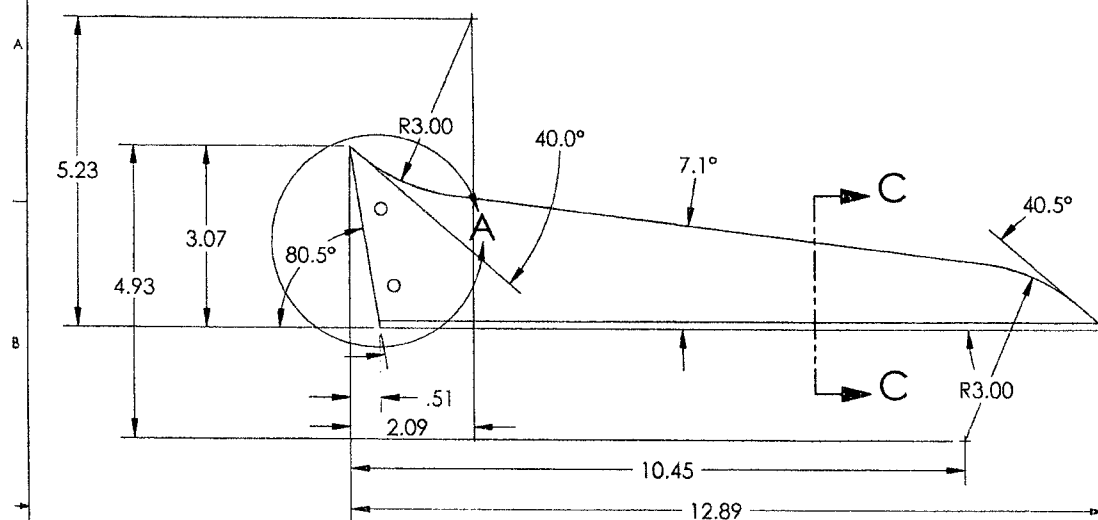


ORIGINAL DATE (MM/DD/YY) 08-26-08 DRAWN BY NAME J. HUFF DRAWING APPROVAL P. SEAYO 26-26-08 CONTRACT NO.	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA, 92056-3512 (760)724-5300			
UPPER CUTTER ASSY				
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMALS ±1 FRACTIONS DECIMALS ±0.005 DECIMALS DECIMALS ±0.001	SIZE 3/8"	CAGE CODE 674726	DWG NO 646.3300	REV 4 OF 4
SCALE 1" = 1"		SHEET 1 OF 1		

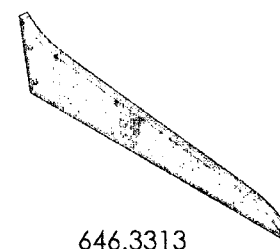
D-12-025

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



DETAIL A



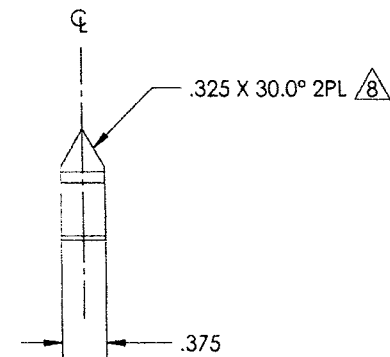
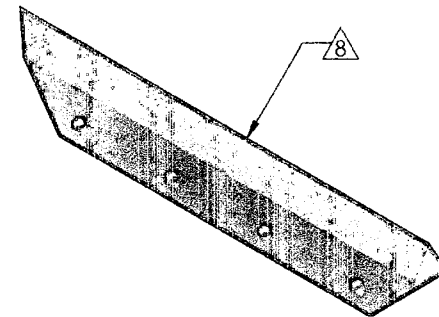
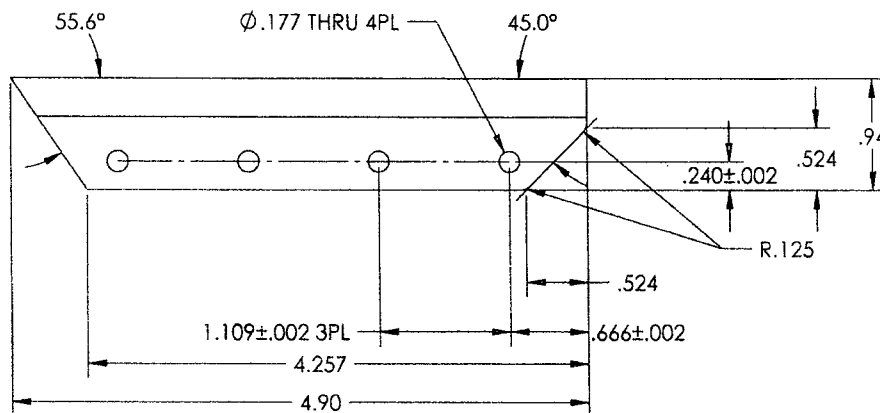
ORIGINAL DATE 10-24-08	08-26-08	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWN BY L. HUI	CHECKED P. BRAVO		
DRAWING APPROVAL P. BRAVO		UPPER CUTTER ASSY	
REVISIONS CONTRACT # 145			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± .5°			
REV B	CAGE CODE 07M16	DWG NO. 646.3300	REV N/C
SCALE NONE		SHEET 5 OF 8	

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300

UPPER CUTTER ASSY

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED

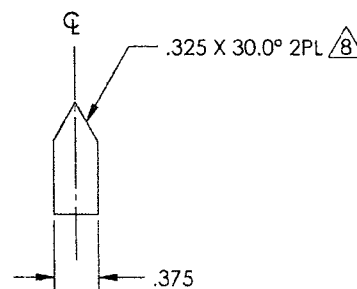
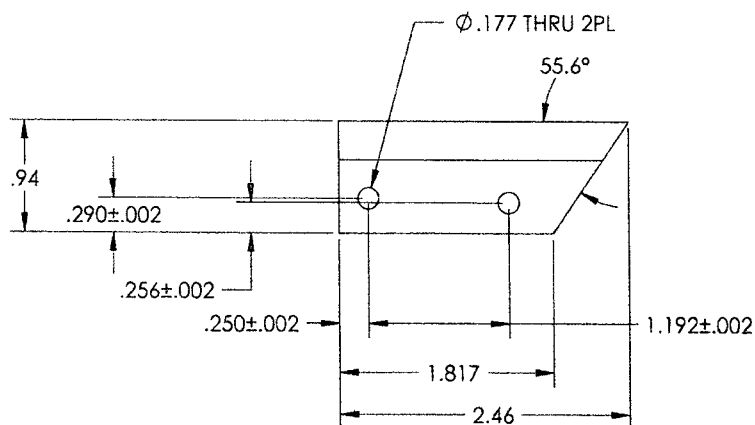
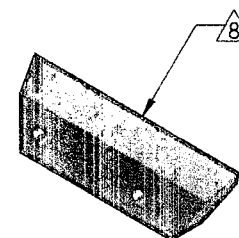


646.3314

ORIGINAL DATE 08-26-08		APICAL INDUSTRIES	
DRAWN BY S. HUFF		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
CHECKED BY P. BRAVO		UPPER CUTTER ASSY	
DRAWING APPROVAL P. BRAVO		SCALE NONE	
CONTRACT NO.		SHEET 6 OF 8	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		REV B	DWG NO 646.3300

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED

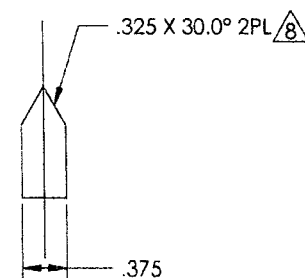
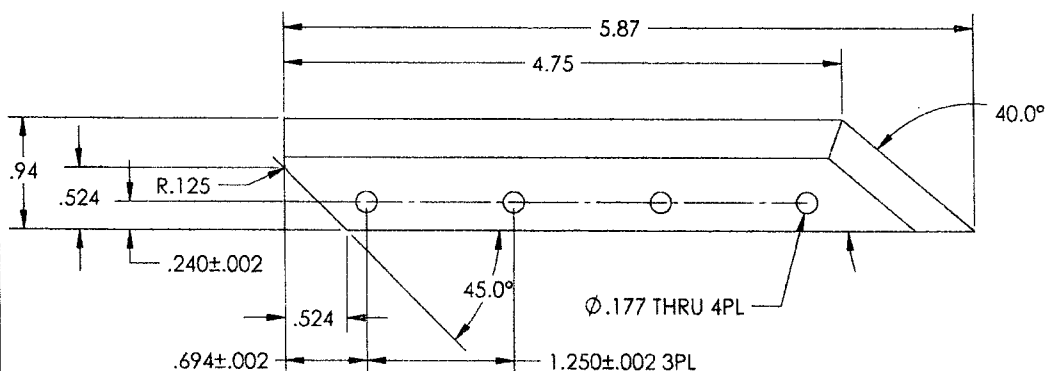
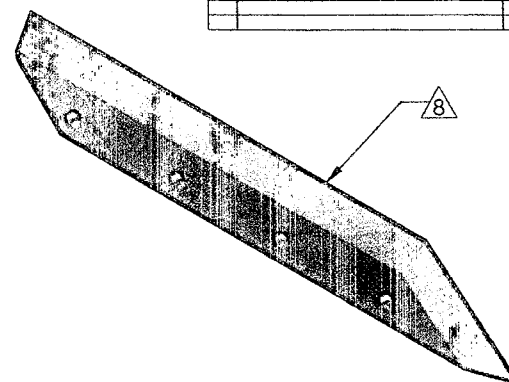


646.3315

ORIGINAL DATE: 09-26-05 DRAWN BY: J. HUFF CHECKED: P. BRAY DRAWING APPROVAL: P. BRAY CONTRACT NO.: 09-26-05		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1 PLACE DECIMALS ±.01 2 PLACE DECIMALS ±.005 ANGLES ± .5°		CAGE CODE: 8 07/126	DWG NO: 646.3300 REV: N/C
SCALE: NONE		SHEET: 7 OF 8	

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DIVISION			
RLY	DESCRIPTION	DATE	APPROVED



646.3316

ORIGINAL DATE (MM-DD-YY) 08-26-08	APICAL INDUSTRIES		
DRAWN BY J. GREEN	2608 TEMPLE HEIGHTS DR.		
CHECKED BY P. BRAYO	OCEANSIDE, CA. 92056-3512 (760)724-5300		
DRAWING APPROVAL P. BRAYO	UPPER CUTTER ASSY		
DATE 8/26/08			
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMALS DIM. 3 PLACE DECIMALS ±.003 3 PLACE DECIMALS ±.000			
REV	QASH CODE	DRG. NO.	REV
B	07MZA6	646.3300	N/A
SCALE NONE		SHEET 8 OF 8	



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 62149

Date: 14-Jan-13

To

DART AEROSPACE LTD
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description	Rev:	
1 lot	Part: ASST		
	24 PCS 647.2510		
	PASSIVATE PER QQ-P-35		
	1 PC 647.1613		
	12 PCS 647.1712		
	3 PCS 647.1810		
	40 PCS 647.1812		
	2 PCS 647.1813		
	1 PC 647.1816		
	20 PCS 646.3312		
	10 PCS 646.3714		
	40 PCS 646.3718		
	20 PCS 646.3811		
	6 PCS 647.7910		
	12 PCS 647.7912		
	6 PCS 647.7916		
	40 PCS 647.9012		
	10 PCS 647.9013		
	19 PCS 647.9016		
	30 PCS 647.9016		
	30 PCS 647.9017		
	60 PCS 647.9017		
	HARD ANODIZE BLACK		
	MIL-A-8625 TYPE III CLASS 2		
	Job: 20130027	PO: PO18583	Line:



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 62149

Date: 14-Jan-13

To

DART AEROSPACE LTD
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7
Canada

Ship To




DART AEROSPACE LTD
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

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Fax: 613-632-1185

Terms	Ship Via				
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Jean-Luc Menard

From: Pablo Bravo <pbravo@apicalindustries.com>
Sent: Monday, December 03, 2012 2:57 PM
To: 'Jean-Luc Menard'
Subject: RE: 646.3312 dimension

JL,
This looks fine to me. We'll get the drawing updated by next week.

Thanks,
Pablo

From: Jean-Luc Menard [<mailto:jmenard@dartaero.com>]
Sent: Monday, December 03, 2012 6:26 AM
To: 'Pablo Bravo'
Subject: 646.3312 dimension

Hi Pablo,
As discussed last Friday the Dimension on Sheet 4 is 1.527" and should be 1.537".
If you could just ok this by e-mail I will attach it to the w/o to keep the parts moving and I will submit an ECR later this week.
THX
JL

Jean-Luc Menard
Production Engineering Coordinator



DART AEROSPACE
1270 Aberdeen Street
Hawkesbury Ontario
Canada K6A 1K7
Tel: (613) 632-5200 Ext 227
jmenard@dartaero.com



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